



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-591-312
Job Sheet 195528



Part No: D350-591-312

Job Qty: 5 pcs

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/24/19

Job Tracking No:

Due Date: 11/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description: order 16580

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq In bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	5 pcs	11/1/19		0.00	5.00	Large Fab - 1		JUN 06 2019
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
120	QC 9	5 pcs	11/1/19		0.00	0.00	QC 9 - 10		DAS 43 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
130	QC 5	5 pcs	11/1/19		0.00	0.00	QC 5 - 10		DAS 43 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 68		
							QC 5 - 9		

DART

AEROSPACE

Container No: S188330



Part: D350-591-312

Job No: 195528

Serial No/Batch: S188330

Revision:

Inspector:

Exp Date:

Dart Aerospace Ltd.

1278 Aberdeen Street

Hawkebury, ON K64 1K7

CANADA

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Container No: S188330



Part: D350-591-312

Job No: 195528

Serial No/Batch: S188330

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 10, FAA STC SUPPLEMENT

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140 Handfinish - 1-1 Chemical-B4B	5 pcs	11/1/19	0.00 0.94	QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	★ JUN 18 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	5 pcs	11/1/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	DAS JUN 20 2019
				QC 7 - 34	24
				QC 7 - 36	9-89
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	

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				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
180 Large Fab - Steps - 2 - B4B	5 pcs	11/1/19	0.00 5.00	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	LC
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
190 QC 10	5 pcs	11/1/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	DAS 24 9-89
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
200 QC 5	5 pcs	11/1/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	DAS 24 9-89
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
210 Handfinish - 1-2- Chemical-B4B	5 pcs	11/1/19	0.00 0.94	Handfinish - 1 - 1 - B4B	sk JUL 29/19
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	

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					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
220 Powdercoat - 1 White Gl(A)- B4B	5 pcs	11/1/19	0.00 1.49		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
230 Handfinish - 3-1- WingWalk- B4B	5 pcs	11/1/19	0.00 0.94		Handfinish - 3 - 1 - B4B	
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
240 QC 3	5 pcs	11/1/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
250 Packaging 1-1 - Pick Kit - B4B	5 pcs	11/1/19	0.00 0.00		Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	

11/7/19
SAR 10:00 OUT 3:30 FINISH 10:30

BL 14-7-29

11/9/19

SEP 25 2019
DAS 40
9-89

74
DAS
9-89

					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
260 QC 4	5 pcs	11/1/19	0.00 0.00		QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	DAS 78
					QC 4 - 74	9-89
270 Packaging 3-1 - Stock - B4B	5 pcs	11/1/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	DAS 78
					Packaging 3 - 25 - B4B	9-89
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Plex 5/24/19 12:59 PM Dart.lajeunesse.marie	

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				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	21
				Packaging 3 - 36 - B4B	21
275 DC - 1 - B4B	5 pcs	11/1/19	0.00 0.00	DC - 1 - B4B	21
				DC - 2 - B4B	21
280 QC 21 - FG	5 pcs	11/1/19	0.00 0.00	QC 21 - FG - 21	21
				QC 21 - FG - 70	21
				QC 21 - FG - 53	21

OCT 08 2019

OCT 08 2019

OCT 08 2019

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jlg DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 138872 3-Grind End Plate flush

120 - QC9- Inspect visual per QSI004- Fusion Welds

130 - QC5- Inspect part completeness to step on W/O

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

180 - Weld per dwg A/R Aluminum rod Batch: _____ 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

190 - QC10- Inspect visual per QSI004- ground welds

200 - QC5- Inspect part completeness to step on W/O

210 - Chemical Conversion Coat per QSI005 4.1

220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

230 - Wing Walk as per dwg QSI005 4.4 Batch _____

240 - QC3- Inspect Part Finish

250 - pick kit

260 - QC4- 100% Inspect kits for completeness

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

280 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	10 pcs (2 ea)	110-Large Fab - Steps - 1	5182946
D3219-1	Plate	10 pcs (2 ea)	110-Large Fab - Steps - 1	5182973
D3272-1	Step	5 pcs (1 ea)	110-Large Fab - Steps - 1	5186993
D3065-041	Step Leg Assembly	5 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	5200131
D3096-1	Spacer	10 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	5183580
MS20600-AD4W4	Rivet	80 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	5193823
AN3-35A	Bolt	10 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5158557
AN4-13A	Bolt	40 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5190190
AN5-36A	Bolt	10 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5202521
D2230-3	Mounting Lug	20 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5194067
D2615	Bushing	10 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5216173
D2865 403 720	Abrasion Strip 4" X 7.20"	10 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5211371
D3235-1	Mounting Lug	10 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5187397
D3278-041	Support Assembly	5 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5217139
MS21042L2	Nut	10 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5204283
MS21042L4	Nut	40 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	8457064
MS21042L5	Nut	10 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5203290
NAS1149D0363J	Washer	20 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5201031
NAS1149D0463J	Washer	80 Ea (16 ea)	250-Packaging 1-1 - Pick Kit - B4B	5192447
NAS1149D0563J	Washer	20 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5174288

DSI 9410-011

IX

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	10	109	0
	D3219-1	10	79	0
	D3272-1	5	15	0
180-Large Fab - Steps - 2 - B4B	D3065-041	5	2	0
	D3066-1	10	3	0
	MS20600-AD4W4	80	1,807	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	10	458	0
	AN4-13A	40	846	0
	AN5-36A	10	147	0
	D2230-3	20	214	0
	D2618	10	247	0
	D2856-400-720	10	20	0
	D3235-1	10	116	0
	D3278-041	5	43	0
	MS21042L3	10	2,198	0
	MS21042L4	40	2,342	0
	MS21042L5	10	781	0
	NAS1149D0363J	20	1,582	0
	NAS1149D0463J	80	3,545	0
	NAS1149D0563J	20	2,970	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		MARB (QSI042)			
Date: _____		Sequence #: _____		QTY Affected: _____		MARB (QSI042)			
Description Work Order Deviation		Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Completed By _____		Lead hand / Supervisor _____		QC / QA Coordinator _____					

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Half-Access-Step™</i> , Short Step - High Skid, LH
	X					D350-591-214	<i>Half-Access-Step™</i> , Short Step - High Skid, RH
		X				D350-591-215	<i>Half-Access-Step™</i> , Short Step - Low Skid, LH
			X			D350-591-216	<i>Half-Access-Step™</i> , Short Step - Low Skid, RH
				X		D350-591-311	<i>Half-Access-Step™</i> , Long Step - High Skid, LH
					X	D350-591-312	<i>Half-Access-Step™</i> , Long Step - High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-38A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.